

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025332**Date Inspected:** 07-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Mai Quin Li**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Traveler Rails & Handrail**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Delbert Humphrey was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 1

**WELDING**

This QA Inspector noted the following Bike Path Hand Rail that had been bent, overstressed damaged, from handling of cable slings and or forklift. The previously inspected Bike Path Handrails were now bent, injured and damaged.

- It appeared that the handrails were bent, distorted, and damaged because of the improper handling.

- Some damages on the handrails appear to be caused by the contact with the forklift.

-It appeared that no softeners were being utilized in between the cable and the Bike Path Handrails during transporting handrails from galvanizing plant.

- The 29 improperly handled handrails are listed below:

PP044, PP042, PP022, PP024, PP022, PP018, PP038, PP016, PP016, PP036, PP030, PP060, PP066, PP032, PP026, PP034, PP080, PP070, PP084, PP028, PP082, PP034, PP062, PP060, PP053, PP052PP064, PP050, PP043.

OBG Bay # 16

**WELDING**

This QA Inspector observed the following work in progress:

SMAW welding of weld identified as W2-SKYWAY-1-001-110, located on Steel Barrier, W2-SKYWAY-1-001.

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

Welder is identified as 053753. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

SMAW welding of weld identified as W5-SKYWAY-1-001-110, located on Steel Barrier, W5-SKYWAY-1-001. Welder is identified as 053753. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

OBG Bay # 14

WELDING

This QA Inspector observed the following work in progress:

SMAW welding of weld identified as TR3003-TR1-001-016, located on Traveler Rail, TR3003-TR1-001. Welder is identified as 066236. ZPMC Quality Control (QC) is identified as Mr. Gou Qui Zing. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G/2F-Fcm-Repair-1 & BWR-20561.

SMAW welding of weld identified as TR3003-TR1-001-016, located on Traveler Rail, TR3003-TR1-001. Welder is identified as 067752. ZPMC Quality Control (QC) is identified as Mr. Gou Qui Zing. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G/2F-Fcm-Repair-1 & BWR-20561.

OBG Bay # 13

WELDING

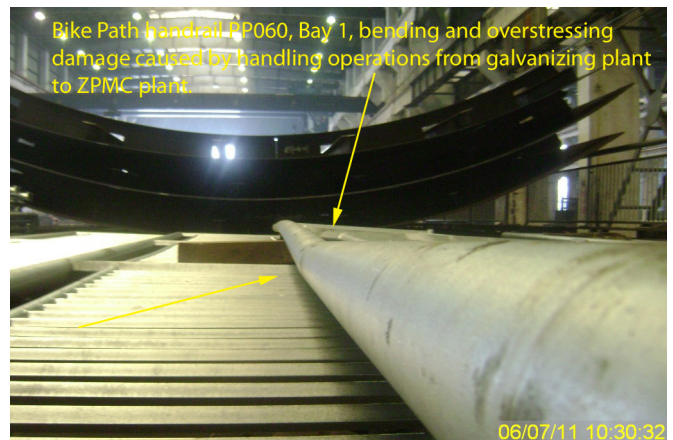
This QA observed the following components in this bay, OBG, Steel Barriers. This QA observed no work being performed on the above mentioned components during the time QA was present.

OBG Bay # 28

WELDING

This QA observed the following components in this bay, OBG, Mock-Up Service Hand Rails. This QA observed no work being performed on the above mentioned components during the time QA was present.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



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## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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### Summary of Conversations:

No relevant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Humphrey, Delbert
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Hall, Steven
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QA Reviewer
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